



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

647.7703

Job Sheet 168199



Part No: 647.7703

Job Qty: 2 ea

Part Name: Strut Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/13/17

Job Tracking No:

Due Date: 11/15/17

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV A2 IPP REV:A 15.01.07 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
150	Outsource	2 pcs		11/14/17	0.00	0.00	Outsource3		
160	Packaging	2 pcs		11/14/17	0.00	0.00	Packaging2		
170	QC	2 pcs		11/14/17	0.00	0.00	QC5		
180	SprayPaint	2 pcs		11/15/17	0.00	0.11	Spray Paint		
190	QC	2 pcs		11/15/17	0.00	0.00	QC14		
200	Packaging	2 pcs		11/15/17	0.00	0.00	Packaging3		
210	QC21-SA	2 Ea		11/15/17	0.00	0.00	QC21		

Part Op 150 - Issue P/O : 038335
Descriptions: 180 - PRIOR TO PRIME MASK THREAD AND PRIME AS PER DWG
B138374

NOV 20 2017
NOV 21 2017

Job Allocations

Job Allocations could not be found.

Part Specifications

Specifications could not be found.

Plex 11/13/17 7:35 AM dart.lavoie.chantal

DART
AEROSPACE

S010371



Strut Assembly

PART NO: 647.7703

Revision:

Operation: Outsource

Change No:

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Mfg Date: 11/15/17

Job No: 168199

SPLIT-2

send back 2 pcs.

Work Order ID 164658

164658

Page 1

Thursday, July 27, 2017 11:50:12 AM

Item ID: 647.7703

Accept

N900040100

Setup Start *NS1*

Revision ID:

SEP 26 2017

DAS
13
9-89

2

4

Stop *NS2*

Item Name: Strut Assembly

Start Date: 8/3/2017 Start Qty: 4.00

Required Date: 9/1/2017 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

DAS
21
9-89

Approvals: Process Plan: UM

Date: 17/7/27 Tooling:

Date:

Run Start *NR1*

QC: _____

Date: _____ SPC (Y/N): _____

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.7700	A2								

110 Pick Kit 0.00

110

Packaging

Memo 0.08

Packaging

120 Weld per dwg A/R 4130 rod Batch: M127925 0.00

120

Large Fab

Memo 0.40

Large Fab

1- ASSEMBLE AND WELD AS PER DWG

***IMPORTANT DIMENSION IS 8.35" ***

(4)

DYC

17/08/17

130 QC9- Inspect visual per QSI004- Fusion Welds 0.00

130

QC

Memo 0.08

Quality Control

(4)

17.03.13

DAS

9

9-89

Work Order ID 164658

Thursday, July 27, 2017 11:50:12 AM

164658

Page 2

Item ID: 647.7703

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Strut Assembly

Start Date: 8/3/2017

Start Qty: 4.00

4

Cust Item ID:

Required Date: 9/1/2017

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.08

Quality Control

①

17-03-10

DAS
9
9-89

150

Outsource process-Cadplate per QSI017 4.1.9.1

0.00

150

Outsource3

Memo

480.00

Outsource process - Cad plate

Issue P/O :

37553

C of C is required

PLEASE NOTE ON PO:

CAD PLATE SHOULD NOT BE TOO THICK AROUND THREAD

4

AUG 25 2017

DAS
13
9-89

2 pcs sent back.

SEP 26 2017

13
9-89

160

Receive & Inspect for Damage & Mat'l Certs

0.00

160

Packaging

Memo

0.08

Packaging

4x SPN-7-11.

Thursday, July 27, 2017 11:50:12 AM

164658

Page 4

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Strut Assembly

Stop *NS2*

Start Date: 8/3/2017 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 9/1/2017 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/
Run Hours**Tool ID****Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

200

Identify as per dwg & Stock Location: _____

0.00

200

Packaging

Memo

0.04

Packaging

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.40

Quality Control

Picklist Print

Thursday, July 27, 2017 11:50:12 AM

Page 1

Work Order ID: 164658

164658

Parent Item: 647.7703

647 7703

Parent Item Name: Strut Assembly

Start Date: 8/3/2017

Required Date: 9/1/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 15.01.07 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.7712 *647 7712* Strut Tube		Manufactured	No			110	Each	67.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA001		67							
				160392		67				4			
647.7713 *647 7713* Strut Thread		Manufactured	No			110	Each	16.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA002		16							
				160398		16				4			
647.7714 *647 7714* Strut Tube		Manufactured	No			110	Each	44.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA001		44							
				159794		4				4			
				160715		40							

**

DYC 17/08/17

**

DYC 17/08/17

**

DYC 17/08/17



SHEET 1 OF 1

REV: A

**PREPARED
BY**

D T. CROSS

DATE: 05/02/16

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: STRUT ASSY

APPROVED BY:

ENGR

MEG

QC

EFF:

CURRENT ORDER

TRANSACTION CODES (TC):

A-ADD C-CREATE

R-REVISE D-DELETE

REASON: REVISED DIMENSION

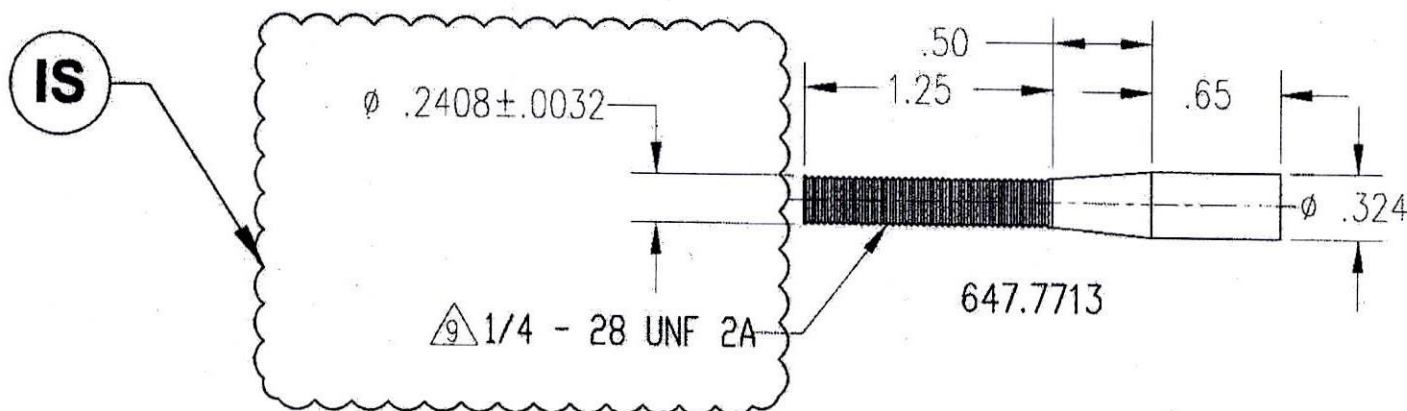
ECR:

16-028

ACTION LIST:

1.

SHEET 2, ZONE D4 IS:



DOCUMENTS EFFECTED:

☐ **PATTERN**

MDL

☐ INSTALL INSTRUCTIONS☐ ICA☐ **BOM****CHANGE CATEGORY**☐ MAJOR☒ MINOR

DER REVIEW REQUIRED

☐ YES☒ NO



APICAL INDUSTRIES, INC.
dba DART AEROSPACE

ENGINEERING CHANGE NOTICE NO.

05110

SHEET 1 OF 1

DWG NO. 647.7700

REV: A

PREPARED BY

A. QUAN

DATE: 08/21/15

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: STRUT ASSY

APPROVED BY:

ENGR

MFG

QC

EFF.

CURRENT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: REVISED FINISH CALLOUT AS PER ECR 15-209

SHEET 1, NOTES IS:

ACTION: UPDATE MO & WO

NOTES:

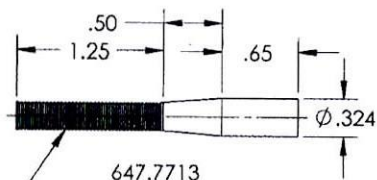
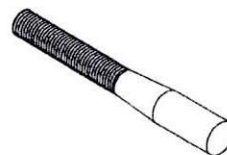
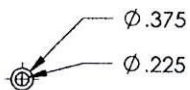
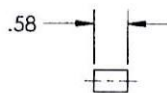
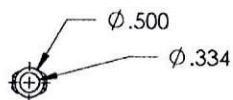
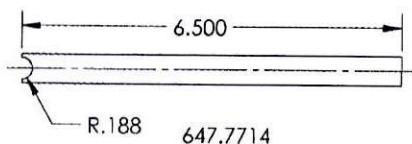
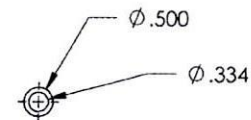
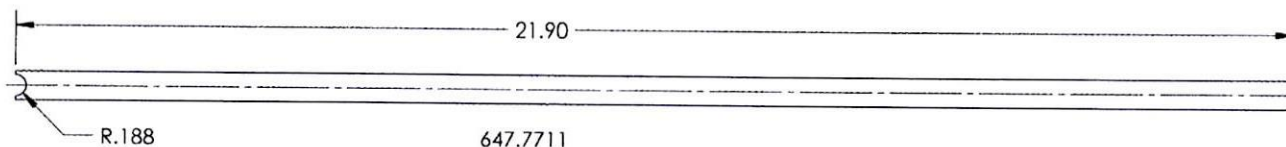
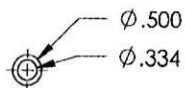
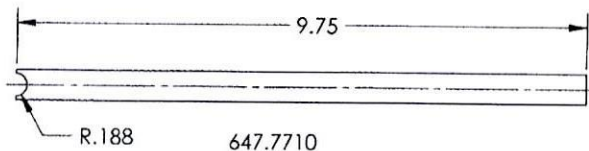
- 1 MATERIAL: 4130 STEEL PER AMS-T-6736, .50" OD, .083" WALL THK.
- 2 MATERIAL: 4130 STEEL PER AMS-T-6736, .375" OD, .075" WALL THK.
- 3 MATERIAL: 4130 STEEL PER AMS-T-6736, .324" OD.
- 4 FINISH: PRIME IAW MIL-P-2337J TYPE I CLASS N; 1-2 MIL MAX
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120.
- 7 WELD IAW MIL-STD-2219. TIG WELD WITH FILLER ROD
- 8 FINISH: CAD PLATE IAW QQ-P-416F CLASS I TYPE II
- 9 MASK THREAD PRIOR TO FINISH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 164658
LM 17/7/27

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED: ☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM					
CHANGE CATEGORY				DER REVIEW REQUIRED	
☐ MAJOR ☐ MINOR				☐ YES ☐ NO	

5	647.7714	STRUT TUBE	△	
4	647.7713	STRUT THREAD	△	△
3	647.7712	STRUT TUBE	△	
2	647.7711	STRUT TUBE	△	
1	647.7710	STRUT TUBE	△	
	647.7703	STRUT ASSY		△△
	647.7702	STRUT ASSY		△△
	647.7701	STRUT ASSY		△△
7703	7702	7701	FIND #	
			PART #	
			DESCRIPTION	
			MAT'L	
			SPEC.	
QTY			PARTS LIST	
NEXT ASSY (S)			APICAL INDUSTRIES	
647.7300			2608 TEMPLE HEIGHTS DR.	
646.4000			OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL			STRUT ASSY	
CONTRACT NO.			REV. A	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.031 2 PLACE DECIMALS ±.063 1 PLACE DECIMAL ±.125			SHEET 1 OF 2	

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.



1/4 - 28 THREAD

ORIGINAL DATE
11/03/00
DRAWN BY
J. JACKSON
CHECKED BY
D. BARKER
DRAWING APPROVAL
P. BRAVO
CONTRACT NO.
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
2 PLACE DECIMALS $\pm .01$
3 PLACE DECIMALS $\pm .005$
ANGLES $\pm .5^\circ$

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300
STRUT ASSY
SHEET 2 OF 2



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37553**

Purchase Order Date 8/25/2017

PO Print Date 8/28/2017

Page Number 1 of 2

Order From :

GROUP ALTECH
2455 HALPERN

VC-ALT01

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

ST LAURENT, MONTREAL H4S 1N9

REVISED

Contact Name

Vendor Phone

514-335-3666

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FOB Origin

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	163807	647.7703 STRUT	9/7/2017 Yes 9/7/2017		4.00	\$12.50	\$50.00
CAD PLATE IAW QQ-P-416F CLASS I TYPE II note: cad plate should not be too thick around tread							
Line Total:							\$50.00
2	164658	647.7703 STRUT	9/7/2017 Yes 9/7/2017		4.00	\$12.50	\$50.00
CAD PLATE IAW QQ-P-416F CLASS I TYPE II note: cad plate should not be too thick around tread							
Line Total:							\$50.00
3	164659	647.7703 STRUT	9/7/2017 Yes 9/7/2017		4.00	\$12.50	\$50.00
CAD PLATE IAW QQ-P-416F CLASS I TYPE II note: cad plate should not be too thick around tread							

Note:

8/28/2017



Certificat de Conformité / Certificate of Compliance



Bon de Livraison / Packing Slip

002174- 1

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date	Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.
06-Sep-2017	Ross Montieth		37553

#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir / Back Order
1	647.7703 Rev.	647.7703 01 -CAD YELLOW 500 [CADMIUM YELLOW 500]	CADMIUM CH	12	12	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements
 Our financial and legal responsibility will not be higher than the amount of invoice.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☒</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☒																																																																							
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Date : 2017/09/21		Step #: 170		QTY Effective : 21			MRB (QS1042) Approval																																																																																								
Description Work Order Deviation				Disposition				5/17/09/21																																																																																							
Found qty +2 pcs w/ite CAD plating Rough. Re. supplier				* Contact supplier AND Return Part to be RE PLATED * RE inspect Part + Reissue in				Completed By																																																																																							
								Lead hand / Supervisor Approval Verification																																																																																							
								QC / QA Coordinator Approval 5/17/09/21																																																																																							
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Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO038335

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO038335
PO Date: 11/13/17
Due Date:
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items												
Line Item	Job	Part	Rev	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	168199	647.7703	-	Strut Assembly Issue P/O : _____		Firmed		2 pcs	0 pcs 2x	2 pcs	\$0.001/pcs	\$0.00
Line Item Note re-work												
2	168198	647.7703	-	Strut Assembly Issue P/O : _____		Firmed		1 pcs	0 pcs 1x	1 pcs	\$0.001/pcs	\$0.00
Line Item Note re-work												
Grand Total:											\$0.00	

Order Notes

DWG REV A2 IPP REV:A 15.01.07 NEW ISSUE DD VERF:JLM

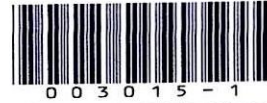
DWG REV A2 IPP REV:A 15.01.07 NEW ISSUE DD VERF:JLM

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/13/17 7:59 AM dart.lavoie.chantal



Certificat de Conformité / Certificate of Compliance



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

003015- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expedition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
03-Oct-2017		Ross Montieth		PO37553					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order	
1	647.7703 Rev.	647.7703 01 -CAD YELLOW 500 [CADMIUM YELLOW 500]	CADMIUM CH	2	2	0	0	0	
2	647.7703 Rev.	647.7703 01 -CAD YELLOW 500 [CADMIUM YELLOW 500]	CADMIUM CH	1	1	0	0	0	

SP 11-14

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.